

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007345**Date Inspected:** 10-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Ming**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Assembly

Bay 13

Segment 8BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CSD2-PP65.5-099, 100, 107, 108. The welder is identified as #044801 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CSD2-PP65.5-091 to 098. The welder is identified as #044801 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-4133.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CSD2-PP65.5-085 to 090. The welder is identified as #044801 and was observed welding in the 2F

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(horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CSD6-PP65-085, 086, 089, 090, 093, 094. The welder is identified as #044801 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CSD6-PP65-063, 064, 069, 070, 065. The welder is identified as #044801 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-4133.

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CSD6-PP65-075 to 084. The welder is identified as #044801 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-B-T-2132.

### Segment 8CE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA054-004. The welder is identified as #055491 and was observed welding in the 2G (horizontal) position using approved Welding Procedure Specification WPS-B-T-2232-TC-U4b-F.

### Segment 8CW

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA053-003. The welder is identified as #069089 and was observed welding in the 1G (flat) position using approved Welding Procedure Specification WPS-B-T-2231-TC-U4b-F.

### Segment 8BE

This QA Inspector observed Flux Cored Arc Welding (FCAW) in progress of a fillet weld joint. The Weld joint is designated as CSD2-PP62.5-039, 040, 035, 036, 031. The welder is identified as #069860 and was observed welding in the 3F (vertical) position using approved Welding Procedure Specification WPS-B-T-2133.

### Plate Yard

This QA Inspector selected a 460mm x 355mm plate check sample and assigned a QA Lot number to the following material:

16mm, A709M-345T2-X

Heat number: 07301514N0

Lot number B222-045-09

Samples were marked with Lot number, date and direction of rolling and will be shipped to an Independent Testing lab.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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